

Claims

1. A method of forming an upper case of a keyboard, said upper case of a keyboard including an opening, said opening defining a rim, said method comprising:
 - (a) filling a mold with plastic substance using said opening as an entrance to form a semi-finished upper case;
 - (b) releasing said mold to retrieve said semi-finished upper case; and
 - (c) affixing a movable housing on said rim of said opening.
2. The method of claim 1, further comprising cutting a scrap between said step (b) and said step (c).
3. The method of claim 2, wherein a diameter of said opening is not less than 1 mm.
4. The method of claim 2, wherein in said step (c), said movable housing is affixed on said rim of said opening by one or more screws.
5. The method of claim 2, wherein in said step (c), said movable housing is lodged in said rim of said opening.
6. The method of claim 2, wherein in said step (c), said movable housing is fused and affixed on said rim of said opening.
7. The method of claim 1, further comprising cutting a gate between said step (b) and said step (c).

8. An upper case of a keyboard, comprising:
a panel including an opening and an integrally formed immovable housing, said opening defining a rim; and
a movable housing affixed on said rim of said opening, wherein said movable housing is formed non-integrally with said panel.
9. The upper case of a keyboard of claim 8, wherein said movable housing is affixed on said rim of said opening by one or more screws.
10. The upper case of a keyboard of claim 8, wherein said movable housing is lodged in said rim of said opening.
11. The upper case of a keyboard of claim 8, wherein said movable housing is fused and affixed on said rim of said opening.